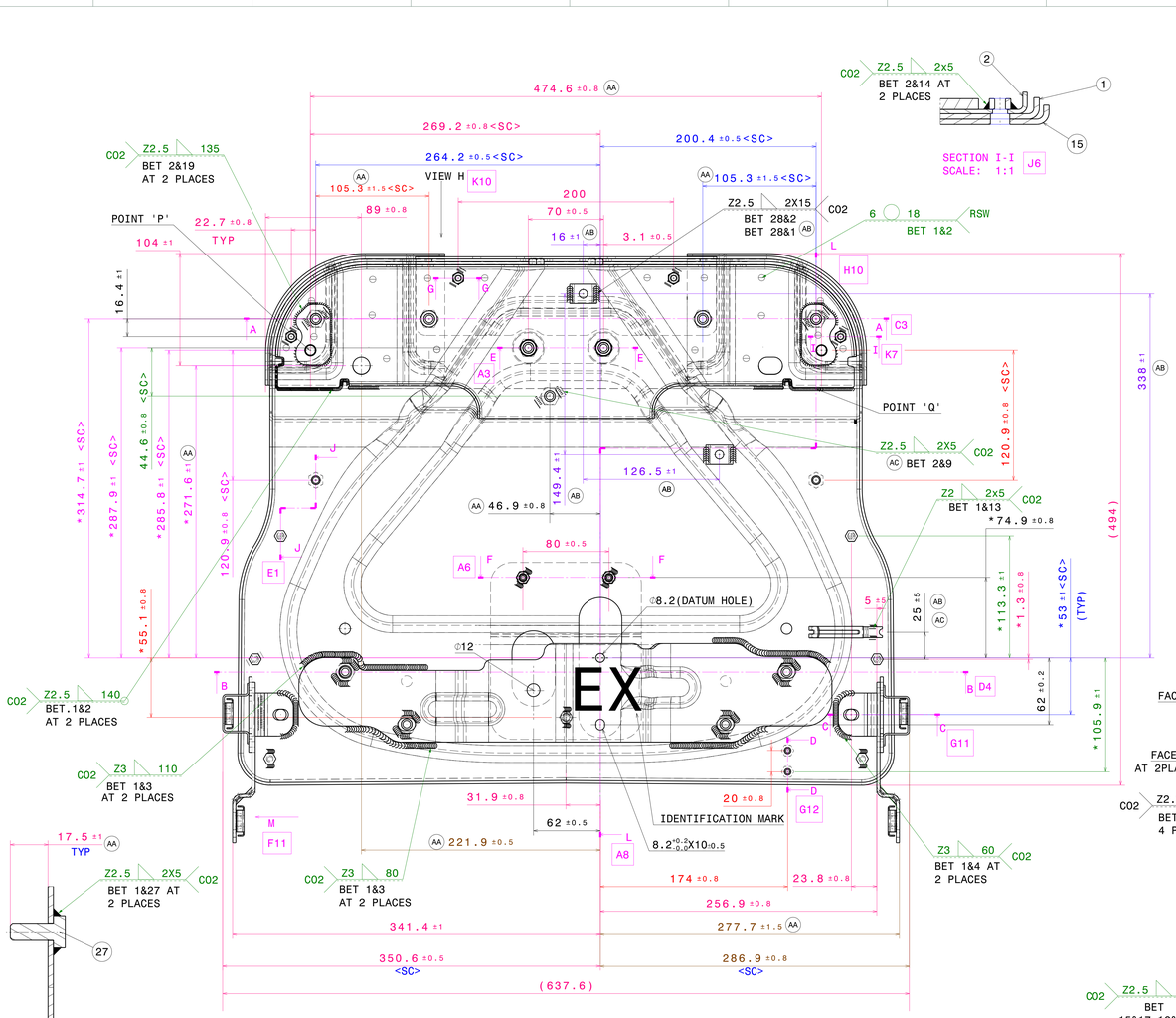

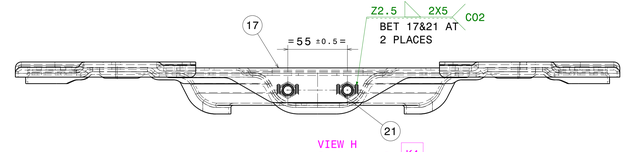

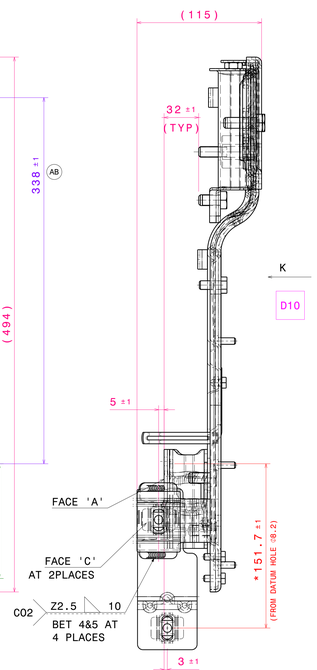

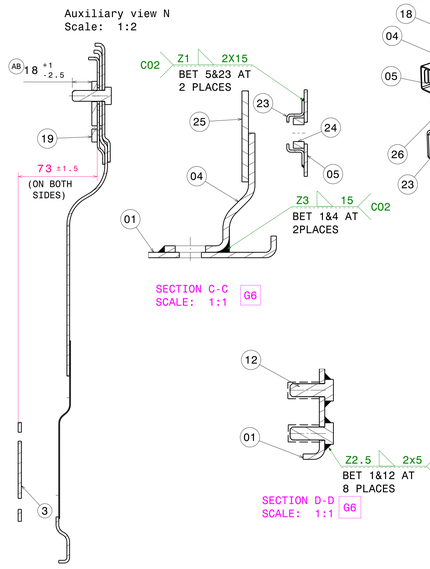

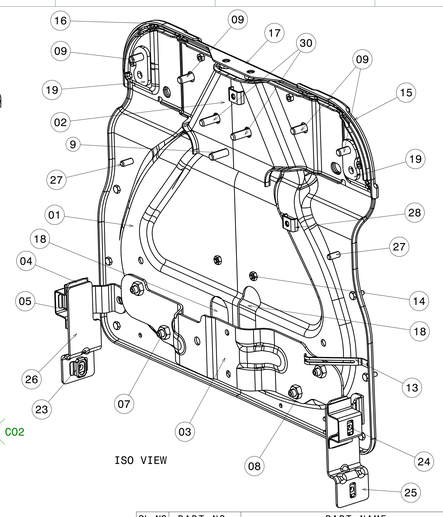

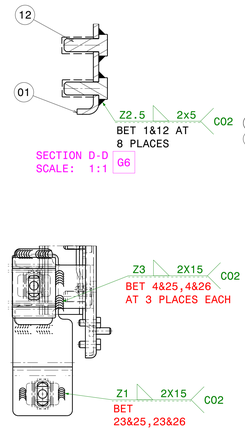

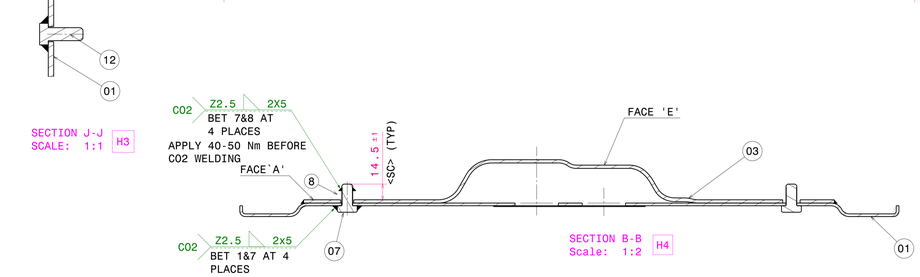

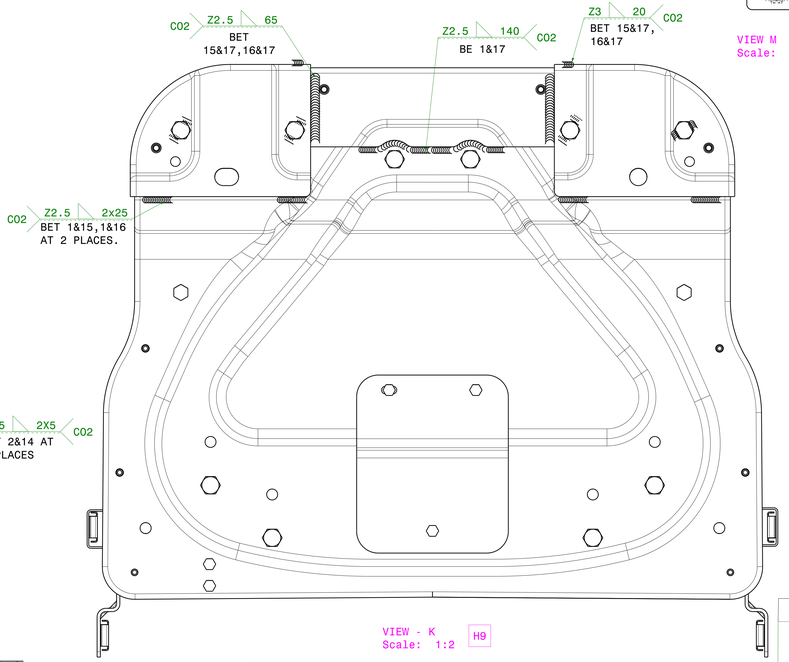

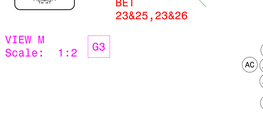

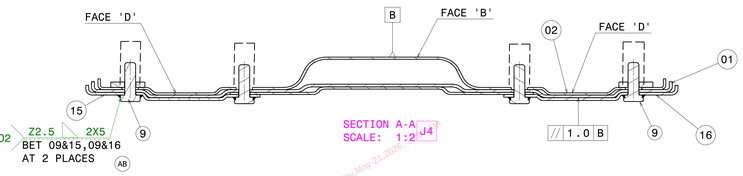

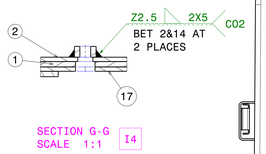

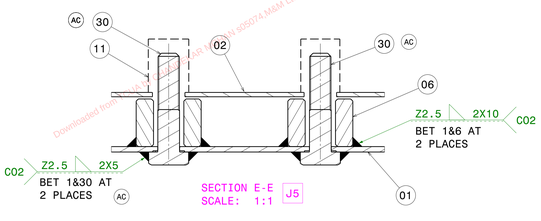

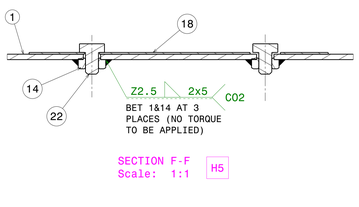

UNSPECIFIED TOLERANCES FOR ASSY

1. GENERAL TOLERANCE
   UP TO 300 : ±0.8
   ABOVE 300 : ±1.0

2. ANGULAR TOLERANCE ±1°

UNSPECIFIED TOLERANCE FOR PARTS

1.FORMING TO FORMING	
< 500	±0.5
> 500	±0.8
2.CD BETWEEN HOLES	
IN ONE PLANE	±0.2
IN DIFF PLANES	±0.5
3.FORM TO PIECE	±0.5
4.ANGULAR TOLERANCE	±1°
5.HOLE SIZES	+0.2/0
6.SLOT SIZES	±0.8
7.GENERAL TOLERANCES	
UPTO 300	±0.8
ABOVE 300	±1.0
8.FLANGE WIDTH	+1.0/-0.7
9.JOGGLE DEPTH	+0.3/0

SL.NO	PART NO.	PART NAME	QTY	WT/PART	WT/ASSY	MATERIAL
1	007541437C1	FIREWALL PANEL	1	5.8483	5.848	MM11-D THK 2.5mm G000169
2	007541441C1	FIREWALL CROSS MEMBER TOP	1	1.1238	1.1238	MM11-D THK 2mm G000169
3	007541445C1	FIREWALL MTG BKT BOTTOM	1	0.9113	0.9113	MM11-D THK 3mm G000169
4	007505834C1	SCUTTLE MTG BKT	2	0.100	0.200	MM11-D THK 3mm G000169
5	007542174C1	SCUTTLE FLOATING NUT MTG BRACKET	2	0.047	0.094	MM21-D THK 1.5mm G000167
6	007541450C1	SPACER	2	0.095	0.19	Fe410W,IS:2062
AC 7	STD	M10X20 HEX BOLT	4	-	-	CLASS 10.9 IS:1367
8	STD	M10 HEX NUT	4	-	-	CLASS 8 IS:1367
AC AB 9	STD	M10X30 HEX BOLT	5	-	-	CLASS 10.9 IS:1367
~~AC AB 10~~	~~STD~~	~~M10X45 HEX BOLT~~	~~2~~	~~-~~	~~-~~	~~CLASS 10.9 IS:1367~~
AA 11		PVC CAP	17	-	-	
12	STD	M6X16 HEX BOLT	8	-	-	CLASS 8.8 IS:1367
13	000060811M01	CLIP HARNESS	1	-	-	
14	STD	M6 WELD NUT	7	-	-	CLASS 6 IS:1367
15	007543224C1	FIRE WALL PANEL BACK REINFORCEMENT LH	1	0.393	0.393	MM11-D THK 2.5mm G000169
16	007543229C1	FIRE WALL PANEL BACK REINFORCEMENT RH	1	0.393	0.393	MM11-D THK 2.5mm G000169
17	007543230C1	FIREWALL PANEL BACK REINFORCEMENT MIDDLE	1	0.4686	0.4686	MM11-D THK 2.0mm G000169
18	007543115C1	FIREWALL PANEL COVER BKT	1	0.1524	0.1524	MM 21-D THK 0.8mm G000167
19	007543240C1	GAS SPRING MOUNTING BACK REINFORCEMENT	2	0.0548	0.1096	MM 11-D THK 5mm G000169
~~20~~	~~STD~~	~~M8X20 HEX BOLT~~	~~2~~			~~CLASS 8.8 IS:1367~~
AA 21	STD	M8 WELD NUT	2			CLASS 8 IS:1367
22	STD	M6X10 HEX BOLT	3			CLASS 8 IS:1367
23	007505978C1	SCUTTLE FLOATING NUT CAGE	4	0.0064	0.0256	MM 21-D THK 1.0mm G000167
24	007505979C1	SQUARE NUT M8	4	0.0073	0.0292	EN8 / EN9
25	007544332C1	SCUTTLE GAUGE MOUNTING BKT LH	1	0.1869	0.1869	MM11-D THK 3mm G000169
26	007544333C1	SCUTTLE GAUGE MOUNTING BKT RH	1	0.1869	0.1869	MM11-D THK 3mm G000169
AA 27	STD	M8X25 HEX BOLT	2			IS:1367,GRADE-8.8
AC AB 28	007544328C91	RELAY MOUNTING BRACKET ASSY	2	0.026	0.026	MM11D
AC 29	007515867 C1	SPACER	2	0.034	0.068	MM13 41O 5MM THK M&M G000169
AC 30	STD	M10 X 55 HEX BOLT	2	0.04	0.08	CLASS 8 IS:1367
		TOTAL			10.22	

WELDING BETWEEN	Z1	WELDING Z2.5	Z3	Z4	SPOT WELDING
1&2		280			18
1&3			380		
1&4			150		
1&6		40			
1&7		40			
AC 1&30		20			
1&12		80			
1&13		10			
1&14		30			
1&15		50			
1&16		50			
1&18		140			
~~1&20~~		~~20~~			
AA 1&27		20			
AC 2&9		10			
2&19		270			
2&14		40			
4&5		40			4
4&25			90		
4&26			90		
5&23	60				
7&8		40			
9&15		20			
9&16		20			
15&17		85			
16&17		85			
17&21		20			
23&25	30				
23&26	30				
AB 28&1		30			
AB 28&2		30			
~~AC AB 29&3~~		~~40~~			
TOTAL	120	1450	710		18 AC

NOTE:-
1.PART MUST BE FREE FROM FRACTURE, FLASH & SHARP EDGES AND ANY SURFACE IMPERFACTIONS, THAT MAY AFFECT FIT OR FUNCTION OF THE PART.

2.PART MUST BE FREE OF STRETCHING, SCORING MARKS AND WRINKLE.

3.UNSPECIFIED RADII SHOULD BE ONE METAL THICKNESS.

4.FACE A,B,C,D&E SHOULD BE FREE FROM WELD SPATTERS.

5.PRIMER SHOULD NOT ALLOWED IN THE THREADED AREA ON SQUARE NUT (PART NO.27),ALL BOLTS & NUTS.

6. PART IS SAME AS 007541439C91 EXPECT "*" MARKED DIMS.

PROCUREMENT CONDITION

PART NO.	FINISH
E0P7543218C91	PRIMED AS PER T04 308 3230

PIN OF Φ8.8 SHOULD PASS THROUGH POINTS 'P' &'Q'

AB TOTAL SURFACE AREA:1066182.38 mm²

AC AB TOTAL WELDING LENGTH =2280mm AS PER PS-608
AA TOTAL NO OF SPOTS=18 PS-625

E.R.NO.	LET	LOC	REVISIONS	DSN	CKR	APPR	DATE
ER17C0 004669	AD	--	PRODUCTION RELEASE	DS	VS	RNM	15.01.15
ECN17F 001525	AC	B3 C12	SL NO:10&29 DELETED. 13&30 ADDED SL NO:7 & 9 QTY UPDATED & WELDING UPDATED	LA	TP	RNM	18.03.17
ECN16P 000323	AB	J4, D10 J10 H14 D13 C15 H7 J5	SL.NO. 9,28 &29 ADDED 18 +0/-5 WAS +33/-5 SL. NO. 10 QTY 2 WAS 6 WELDING UPDATED SURFACE AREA UPDATED DIM 25±5 ADDED DIM 16±1,126.5±1,149.4±1, 338±1 ADDED	DS	SK	RNM	15.09.15
ECN15P 020100	AA	H2,K4 F3 F13 I10 C13 G13 F5 I4	DRAWING UPDATED AS PER CDMM FEEDBACK <SC>REMOVED FROM DIM.231.6±1, 474.6±0.8,221.9±0.5,17.5±1 SL.NO.20 DELETED & SL.NO.27 ADDED DIM.33+0/-5 ADDED WELDING UPDATED SL.NO.9 DELETED & SL.NO.10 QTY 6 WAS 2 & SL.NO.11 QTY 12 WAS 11. 277.7±1.5 WAS 277.7±1 105.3±1.5,46.9±0.8 WERE 105.3±0.8,46.9±0.5.	DS	SK	RNM	12.01.15

<SC> :SIGNIFICANT CHARACTERISTICS ▽ :CRITICAL CHARACTERISTICS

BREAK SHARP CORNERS MAY BE EITHER A CHAMFER OR A RADIUS FROM 0.2 mm MIN. TO 1.0 mm MAX

ASPECIFIED TOLERANCES AS PER ISO-2768-1:1989

DIMENSIONS IN mm.		OVER 0.5	3	6	30	120	400	1000	2000
		UPTO 3	6	30	120	400	1000	2000	4000
f FINE	(X.XX)	±0.05	±0.05	±0.1	±0.15	±0.2	±0.3	±0.5	-
m MEDIUM	(X.XX)	±0.1	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2
c COARSE	(X.X)	±0.2	±0.2	±0.3	±0.8	±1.2	±2	±3	±4
v VERY COARSE	(X)	-	±0.5	±0.5	±1.5	±2.5	±4	±6	±8

ANGULAR IN deg.	LENGTH OF SHORTER SIDE OF THE ANGLE IN mm. OVER	-	10	50	120	400
	UPTO	10	50	120	400	-
f FINE	(X.XXX)	±1.-	±0.40'	±0.20'	±0.10'	±0.05'
m MEDIUM	(X.XX)					
c COARSE	(X.X)	±1.-20'	±1.-	±0.30'	±0.25'	±0.10'
v VERY COARSE	(X)	±3.-	±2.-	±1.-	±0.20'	±0.20'

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IF IN DOUBT, ASK DO NOT SCALE DRG SIZE : A0

MAHINDRA & MAHINDRA LIMITED
TRACTOR DIVISION
KANDIVLI(EAST), MUMBAI 400 101. INDIA.

E.R. / PROC.RED.NO ER17C0004669 | PART NO. E00754321 8C91

PART NAME: FIREWALL ASSY COMPLETE EXPORT

MATERIAL : REFER TABLE | HEAT TREATMENT :

	NAME	SIGN	DATE	FIRST USED TRCR. MODEL
2014				
CAD ENG.	TR		15-10-14	MSTAR EXPORT
DESIGNER	TR		15-10-14	SCALE 1:2
CHECKER	SK		15-10-14	SHEET 1 OF 1
APPR.BY	RNM		15-10-14	UNIT QTY. 1 TR
				WEIGHT 10.22 kg

ALL DIMENSIONS ARE IN mm. CHECK DRG WITH LATEST CHANGE

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